

DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE	ENGINEERING CHANGE NOTICE NO. 04948				SHEET 1 OF 2	
	DWG NO. 647.3900	REV: C	PREPARED BY: M. ANDECK	DATE: 05/04/15	EFFECT ON DWG <input type="checkbox"/> INC. <input checked="" type="checkbox"/> UNINC.	
	DWG TITLE: DEFLECTORS					
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE		APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER	
REASON: REVISED TOLERANCE AND NOTES					ECR: D-15-01	

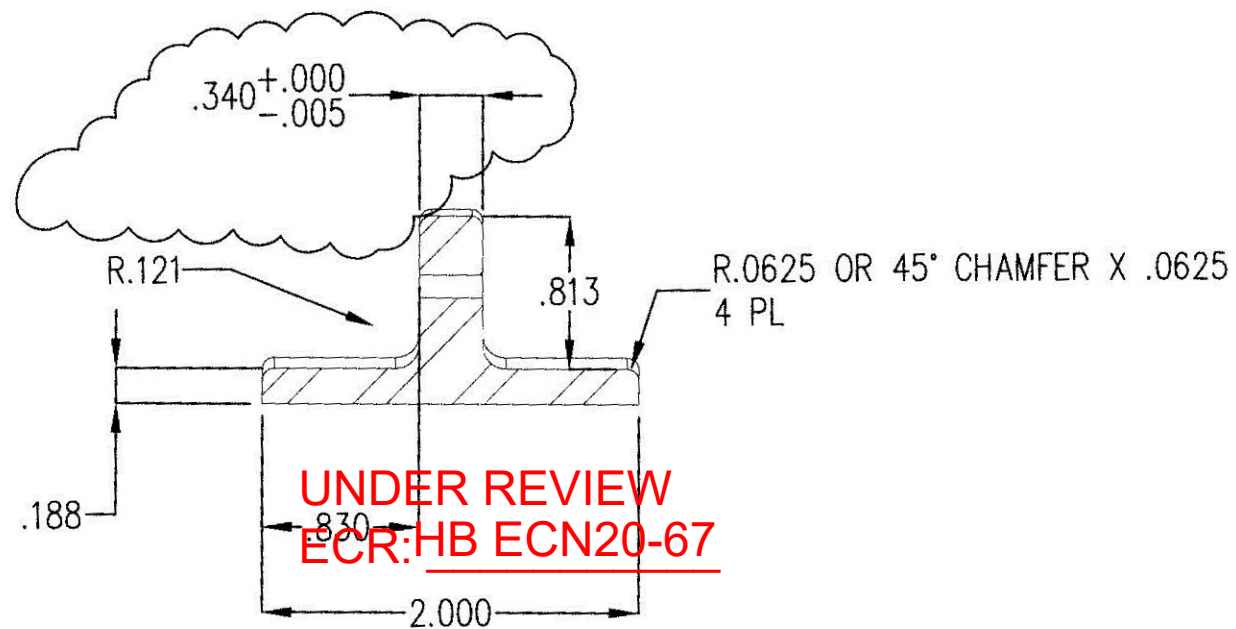
NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
- 7 .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
- 8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.
- 10 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4.

UNDER REVIEW
ECR: HB ECR20-67

SHEET 1, ZONE B1 IS:

11	R	647.3917	2			DOUBLER		
F/N	TC	PART NUMBER	.3903	.3902	.3901	DESCRIPTION	MATERIAL	SPECIFICATION
			QTY					
DOCUMENTS EFFECTED:							CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> PATTERN <input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUC <input type="checkbox"/> ICA <input checked="" type="checkbox"/> BOM							<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO



SECTION AT-AT

SHEET 11, ZONE C1 IS:

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04556

SHEET 1 OF 2

DWG NO. 647.3900

REV: C

PREPARED BY D. MEJIA

DATE: 06/10/2014

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: DEFLECTORS

APPROVED BY: ENGR *[Signature]*

MFG *[Signature]* QC *[Signature]*

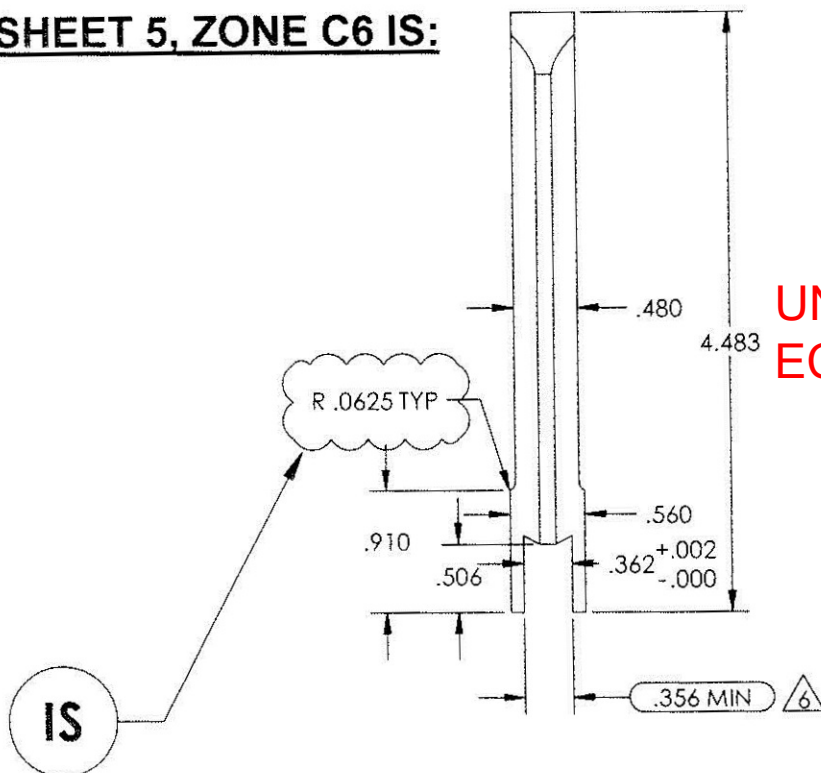
EFF. NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

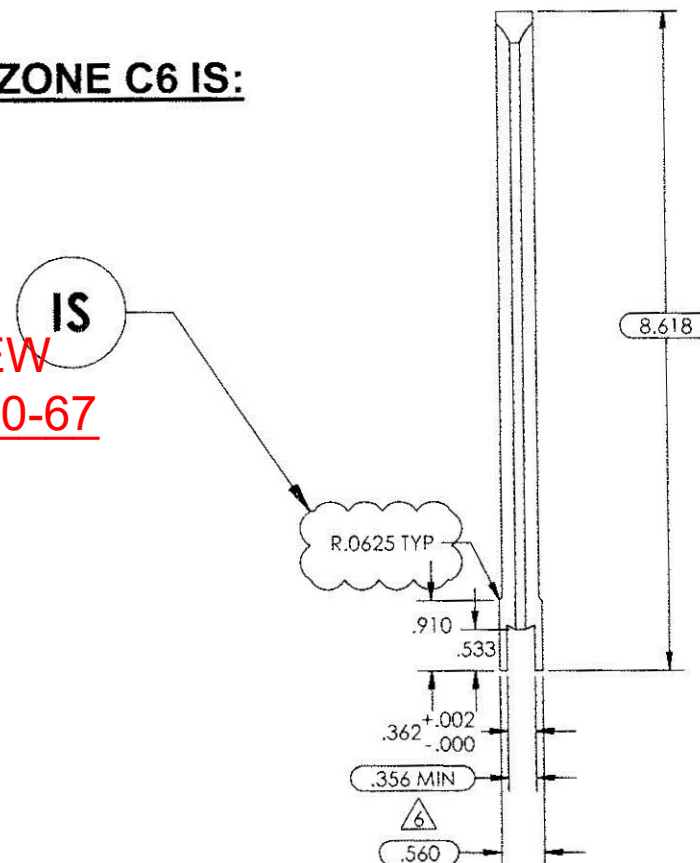
REASON: CHANGED P/N, DIMENSIONS & REVISED BOM

ECR: D-14-04

SHEET 5, ZONE C6 IS:



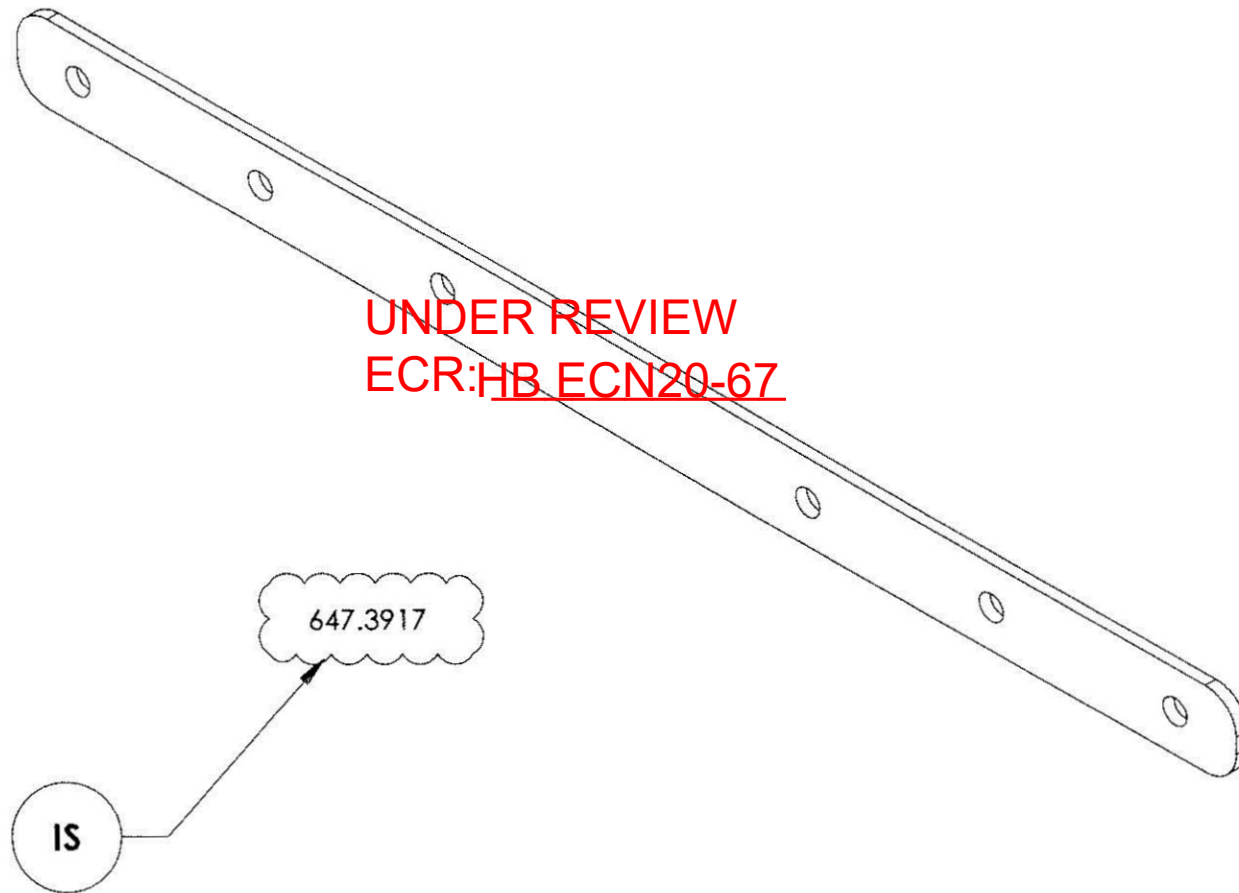
SHEET 6, ZONE C6 IS:



UNDER REVIEW
ECR: HB ECN20-67

SHEET 1, BOM IS:

11	R	647.3917	2		DOUBLER	1	8
F/N	TC	PART NUMBER	3903	3902	3901	DESCRIPTION	SPECIFICATION
			QTY				
DOCUMENTS EFFECTED:						CHANGE CATEGORY	DER REVIEW REQUIRED
<input type="checkbox"/> MDL <input type="checkbox"/> INSTALL INSTRUCTIONS <input type="checkbox"/> ICA <input type="checkbox"/> FMS <input checked="" type="checkbox"/> BOM						<input type="checkbox"/> MAJOR <input checked="" type="checkbox"/> MINOR	<input type="checkbox"/> YES <input checked="" type="checkbox"/> NO

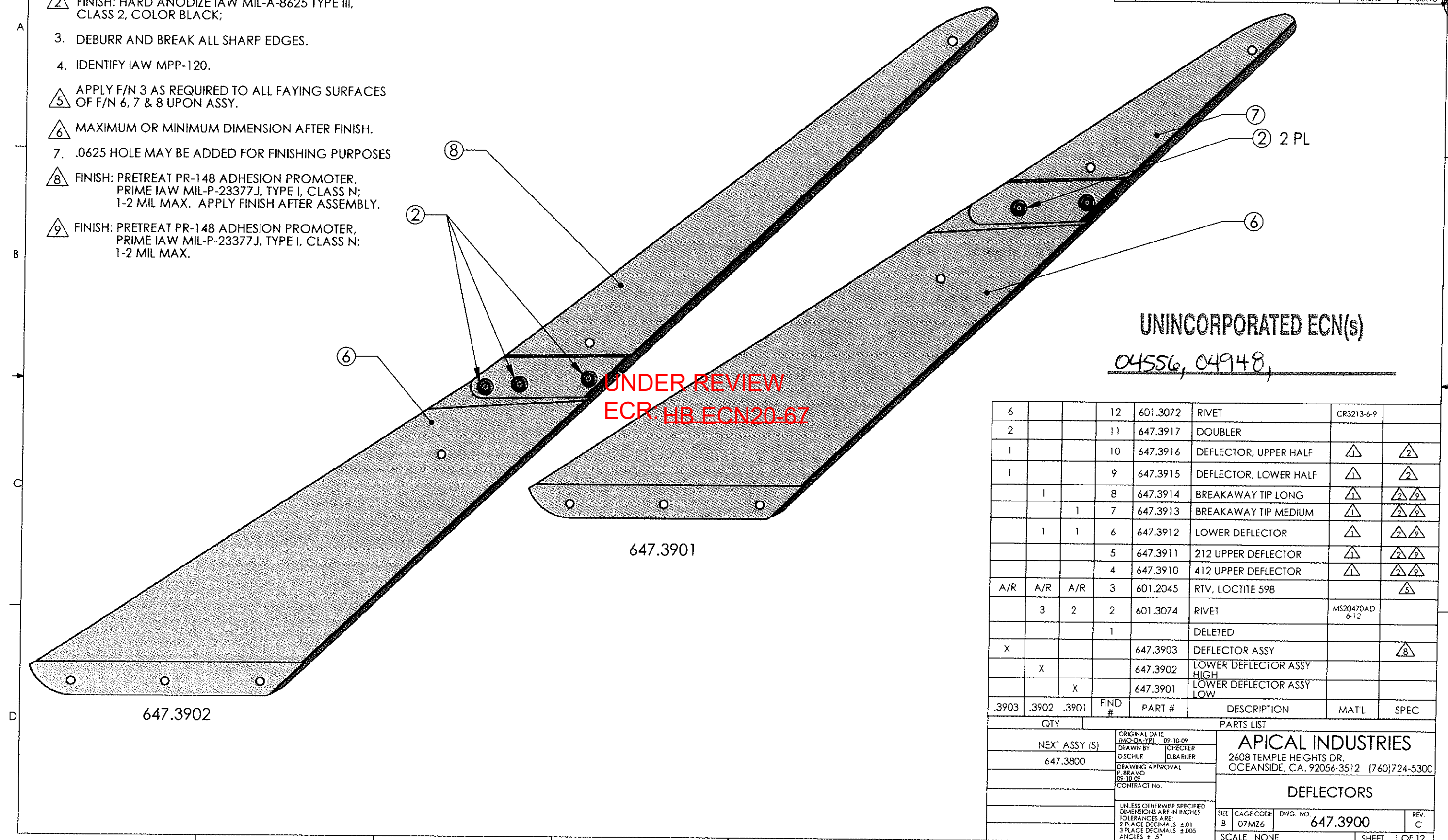
SHEET 12, ZONE B5 IS:

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NOTES:

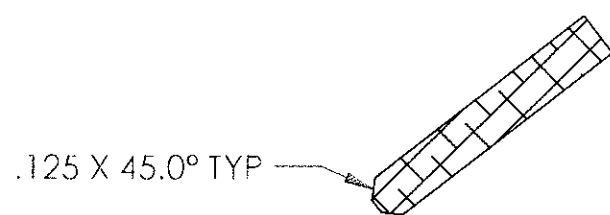
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
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- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377J, TYPE I, CLASS N; 1-2 MIL MAX.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE: PR1		N/C
N/C	INITIAL RELEASE	09/10/09	P. BRAVO
A	INCORPORATED ECN 02864, 03539 & 03595	07/24/12	P. BRAVO
B	INCORPORATED ECN 04025	08/02/13	P. BRAVO
C	INCORPORATED ECN 04038, 04085 & 04250	11/18/13	P. BRAVO

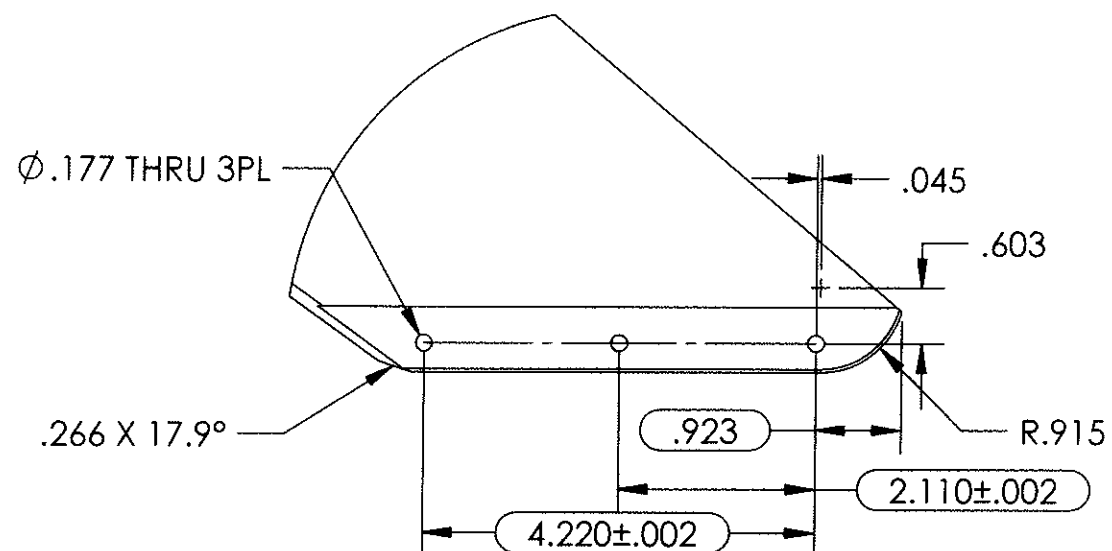


6			12	601.3072	RIVET	CR3213-6-9	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△
			5	647.3911	212 UPPER DEFLECTOR	△	△
			4	647.3910	412 UPPER DEFLECTOR	△	△
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	2	601.3074	RIVET	MS20470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
	X			647.3902	LOWER DEFLECTOR ASSY HIGH		
		X		647.3901	LOWER DEFLECTOR ASSY LOW		
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MAT'L	SPEC
QTY				PARTS LIST			
NEXT ASSY (S)				ORIGINAL DATE 09-10-09			
647.3800				DRAWN BY D.SCHUR CHECKER D.BARKER			
				DRAWING APPROVAL P. BRAVO 09-10-09			
				CONTRACT No.			
				UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300			
				DEFLECTORS			
				SIZE CAGE CODE DWG. NO. 647.3900 REV. C			
				SCALE NONE SHEET 1 OF 12			

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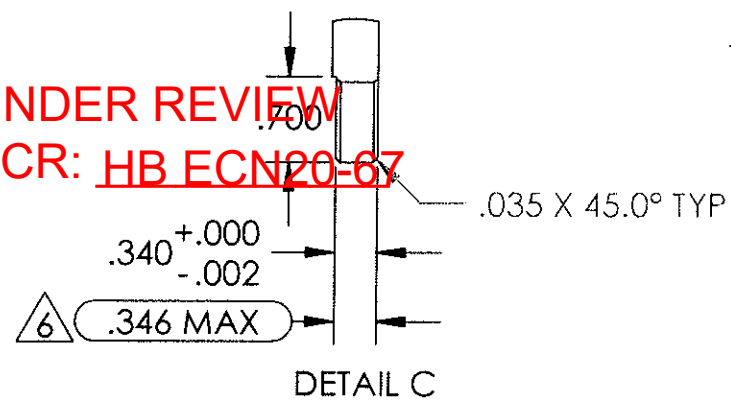


SECTION B-B

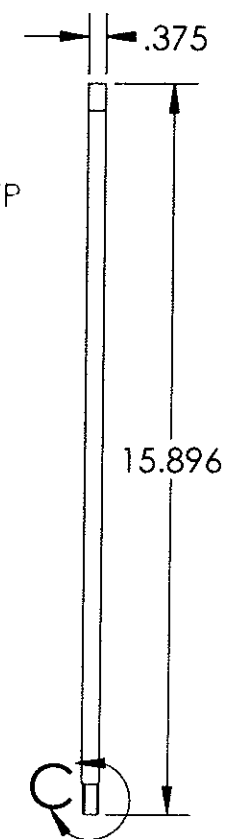


DETAIL A

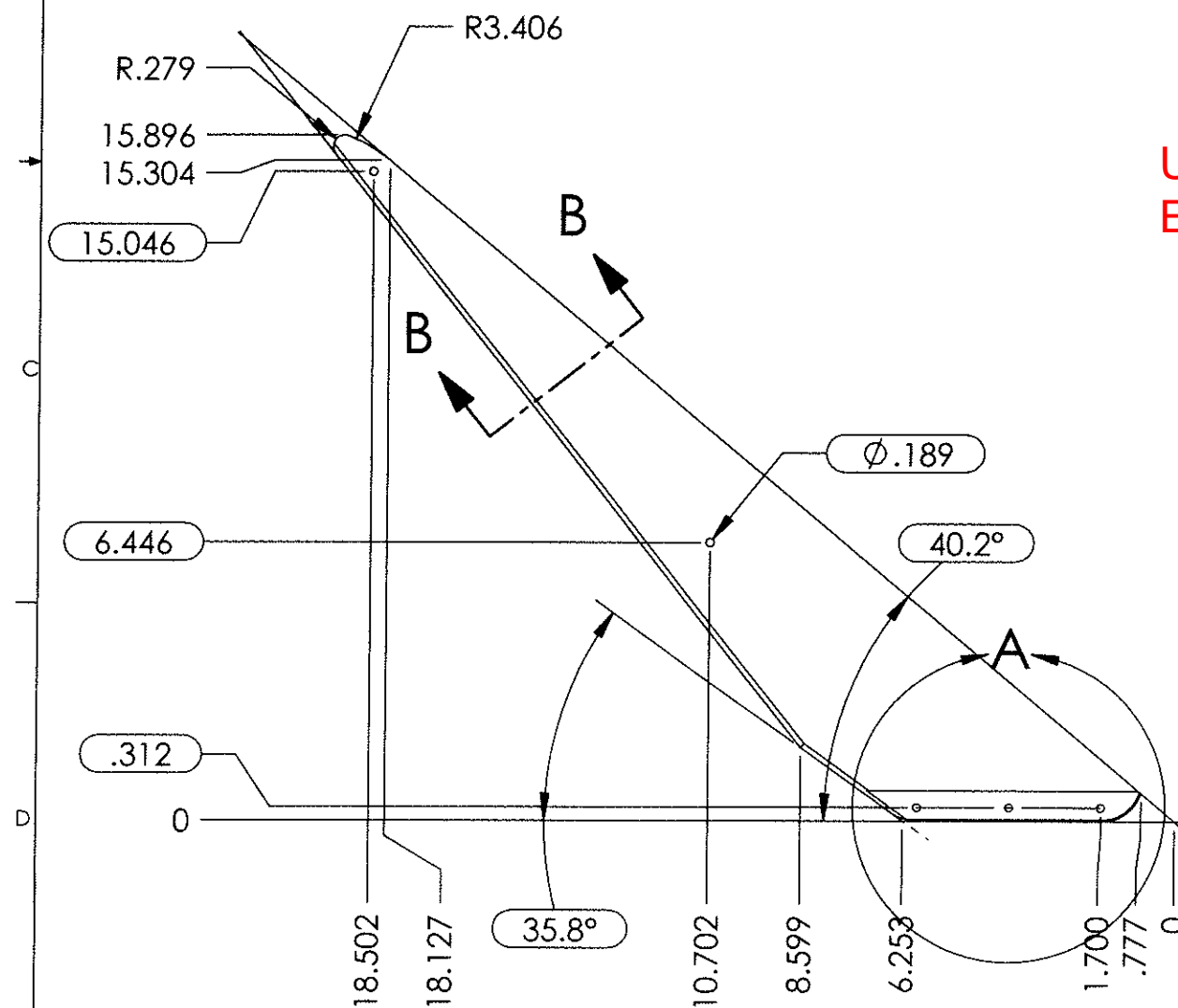
UNDER REVIEW
ECR: ~~HB ECN20-67~~



DETAIL C

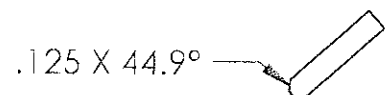


647.3911

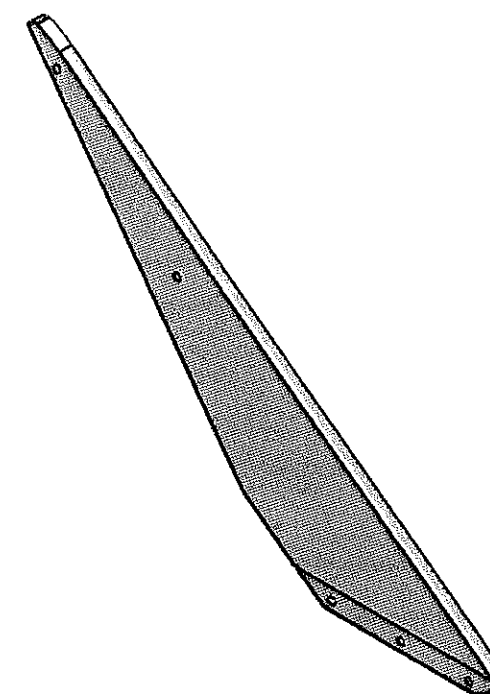
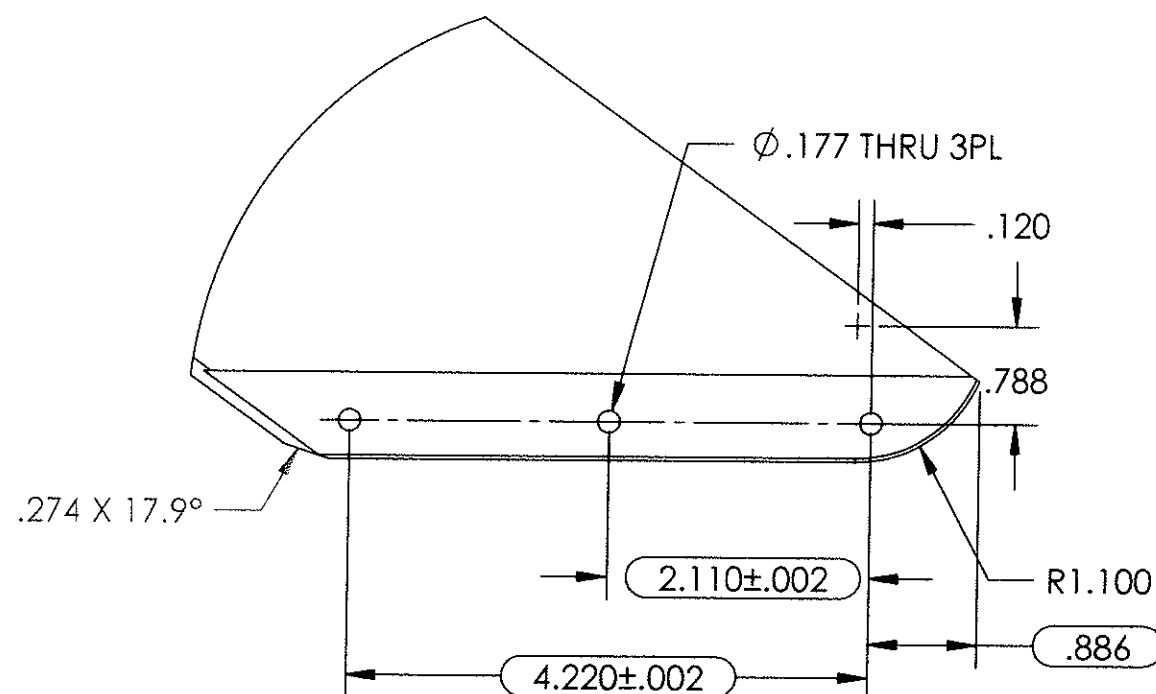


ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CHECKER D.BARKER		DEFLECTORS	
DRAWING APPROVAL P. BRAVO		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	
CONTRACT No.		SIZE B	CAGE CODE 07MZ6
		DWG. NO. 647.3900	REV. C
		SCALE NONE	SHEET 2 OF 12

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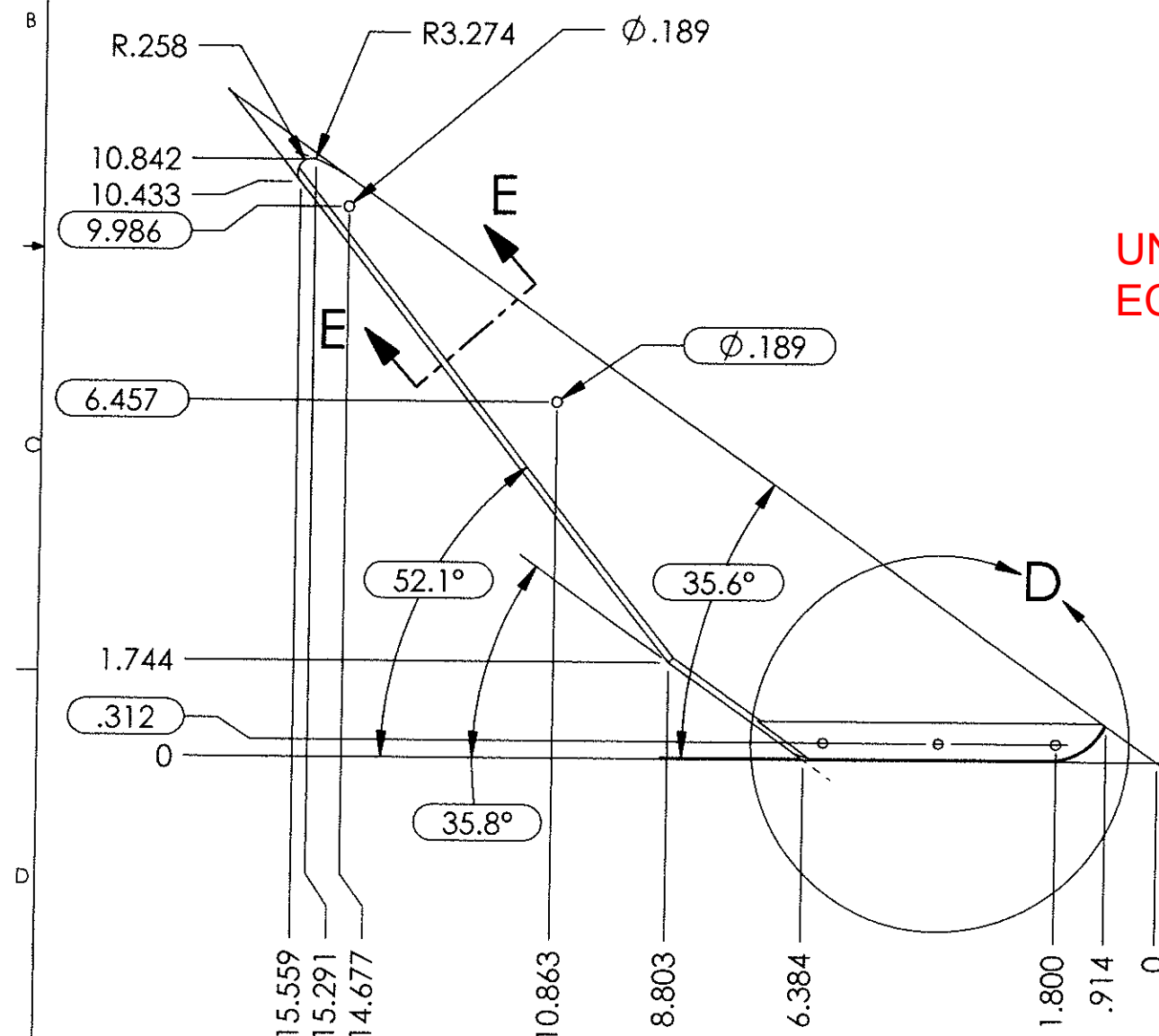
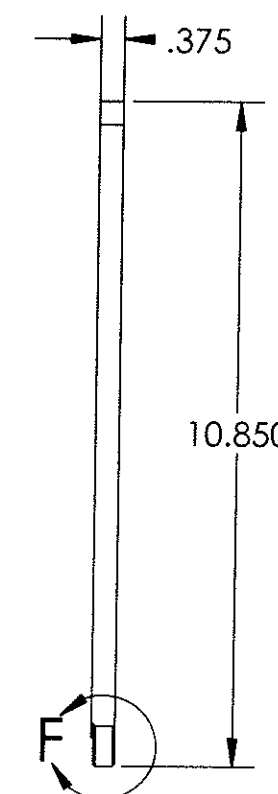
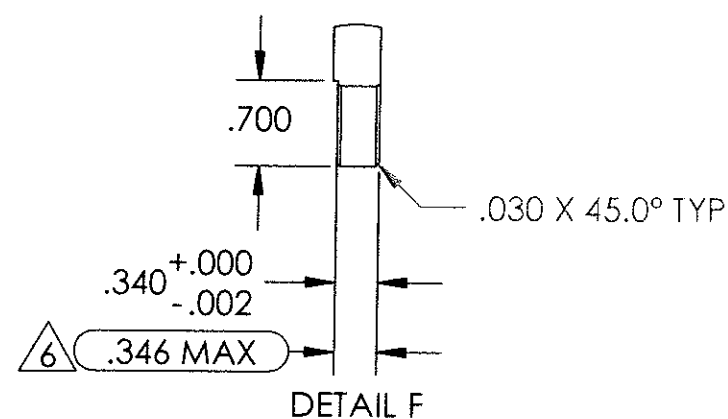
SECTION E-E



647.3910

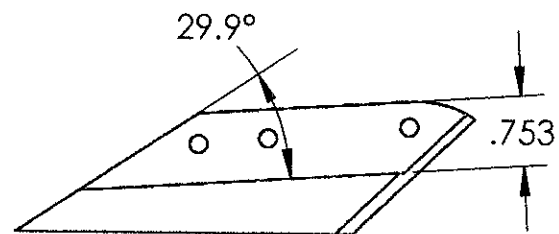
DETAIL D

UNDER REVIEW
ECR: HB ECN20-67

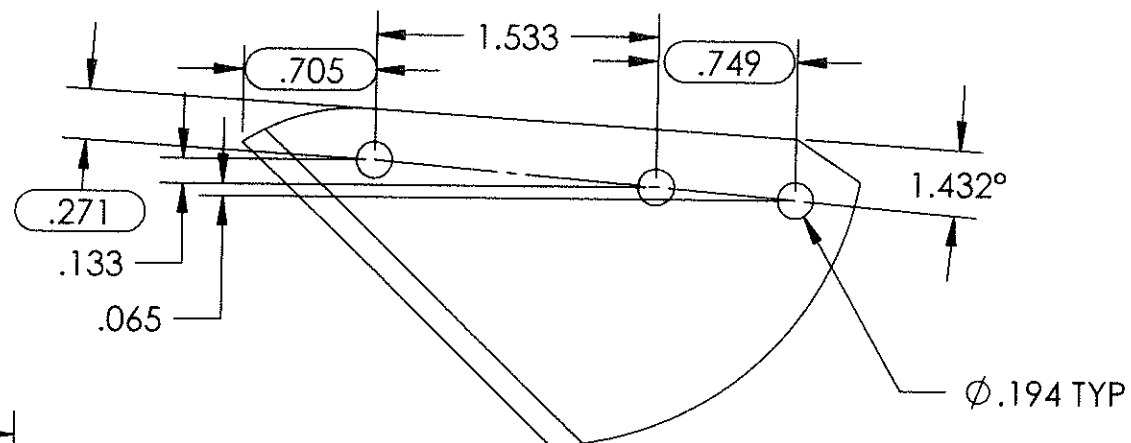


ORIGINAL DATE JMO-DA-YRJ 09-10-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.SCHUR	CHECKER D.BARKER		
DRAWING APPROVAL P. BRAYO		DEFLECTORS	
CONTRACT No.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± 5°		SIZE B	REV. C
		CAGE CODE 07MZ6	DWG. NO. 647.3900
		SCALE: NONE	
		SHEET 3 OF 12	

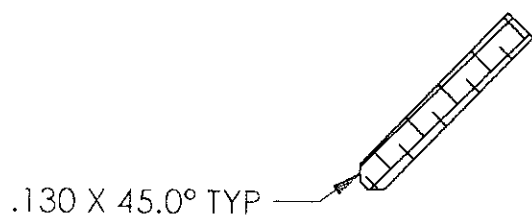
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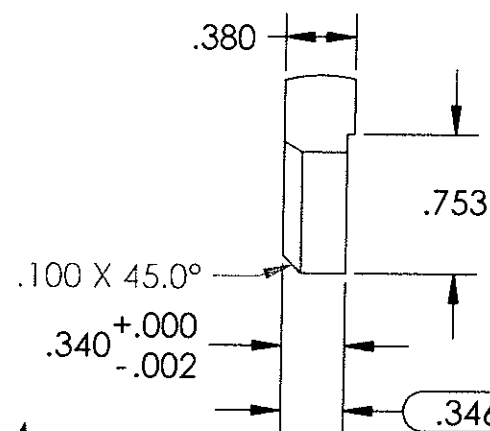
SECTION L-L



DETAIL H

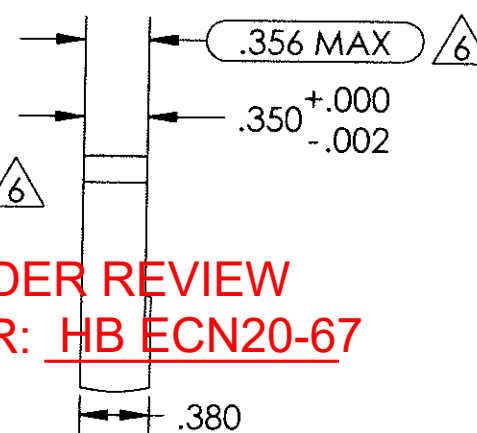


SECTION M-M

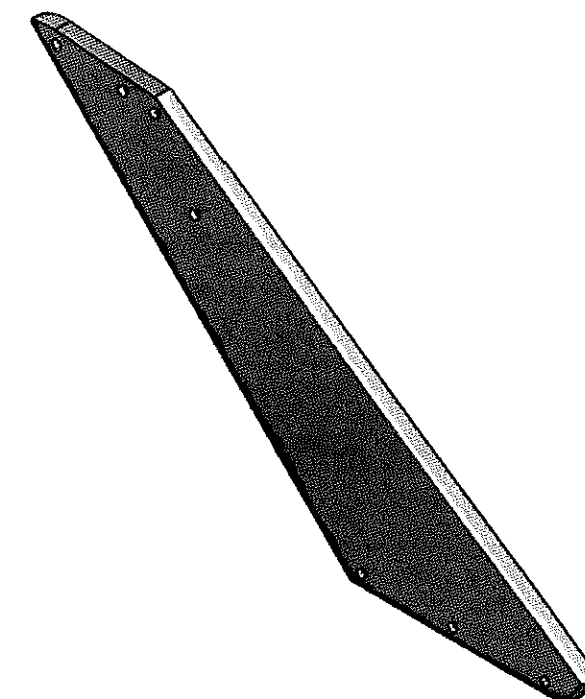
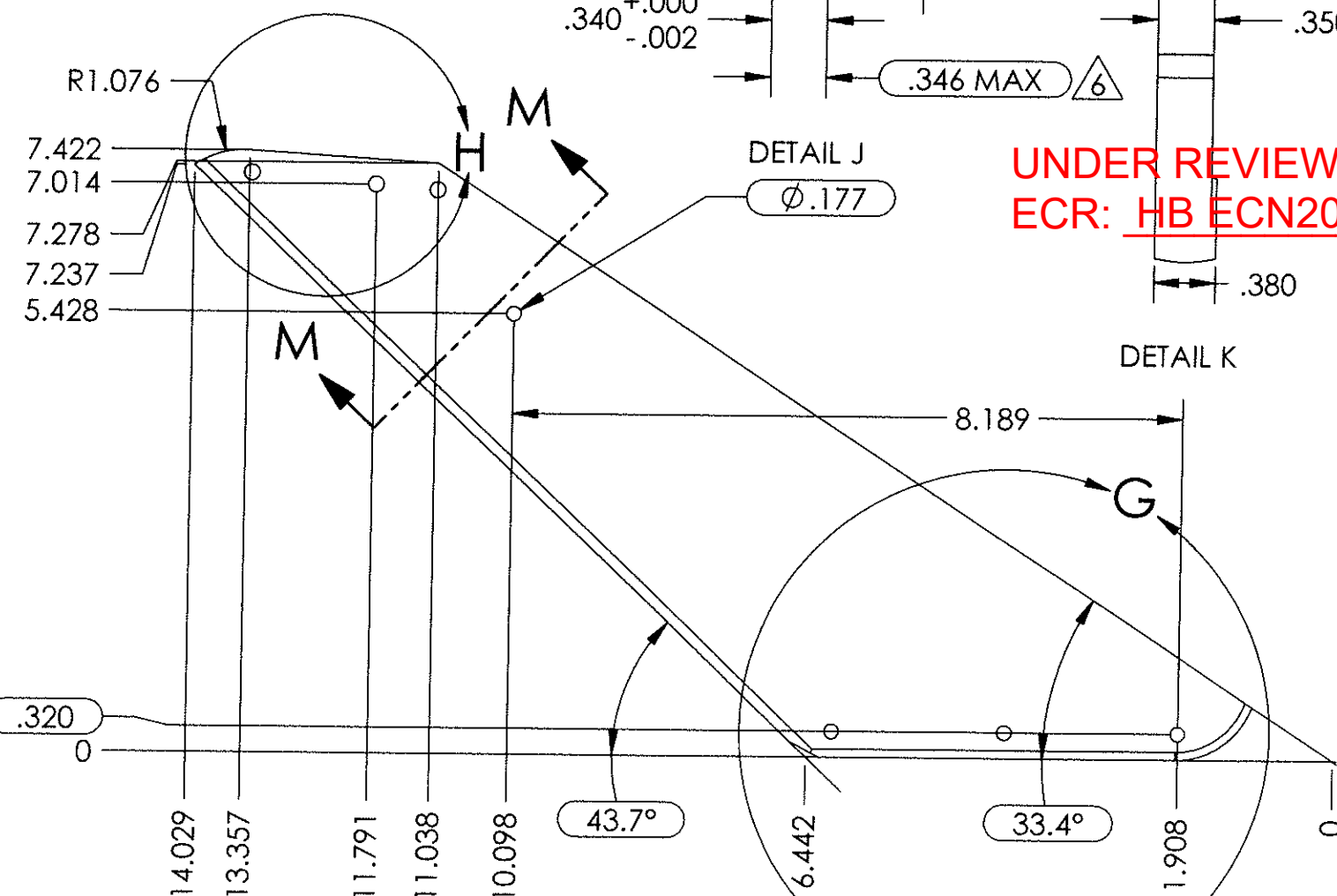


DETAIL J

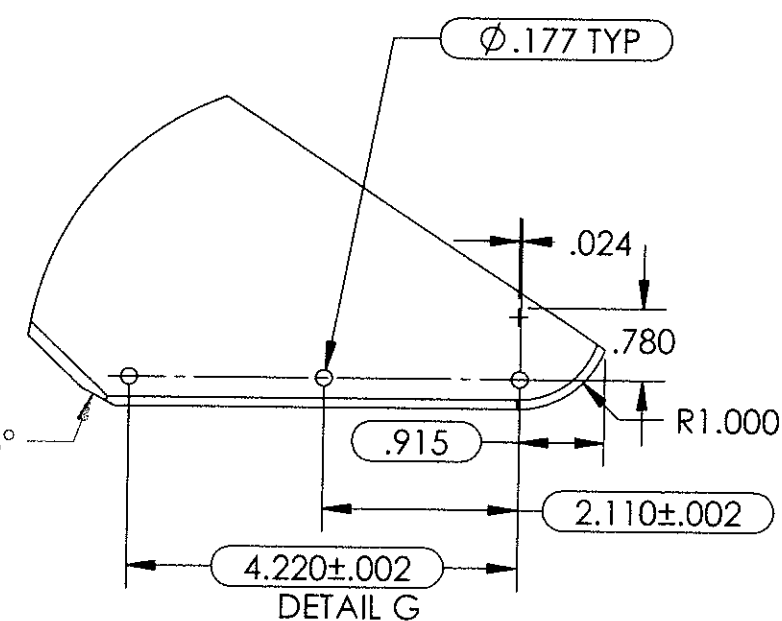
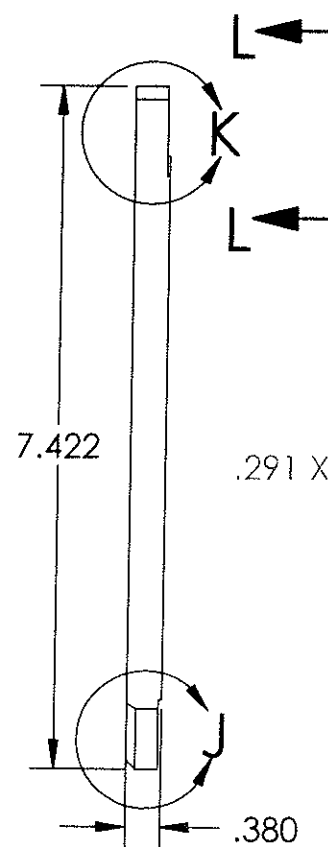
UNDER REVIEW
ECR: HB ECN20-67



DETAIL K

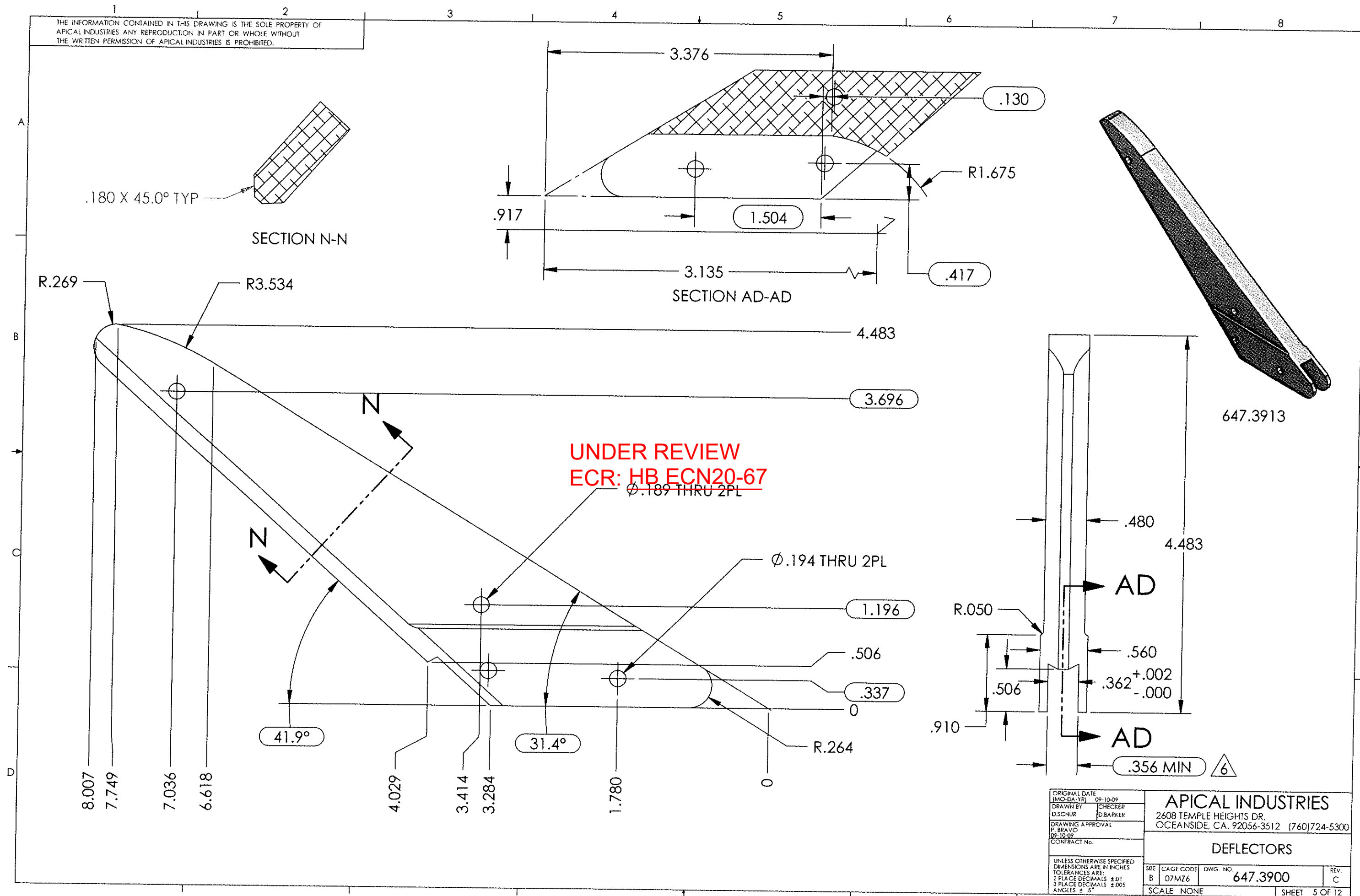


647.3912



ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		2608 TEMPLE HEIGHTS DR.	
CHECKER D.BARKER		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		DEFLECTORS	
CONTRACT No.		DWG. NO. 647.3900	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV. C
		CAGE CODE 07MZ6	SHEET 4 OF 12
		SCALE NONE	

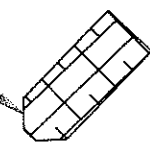
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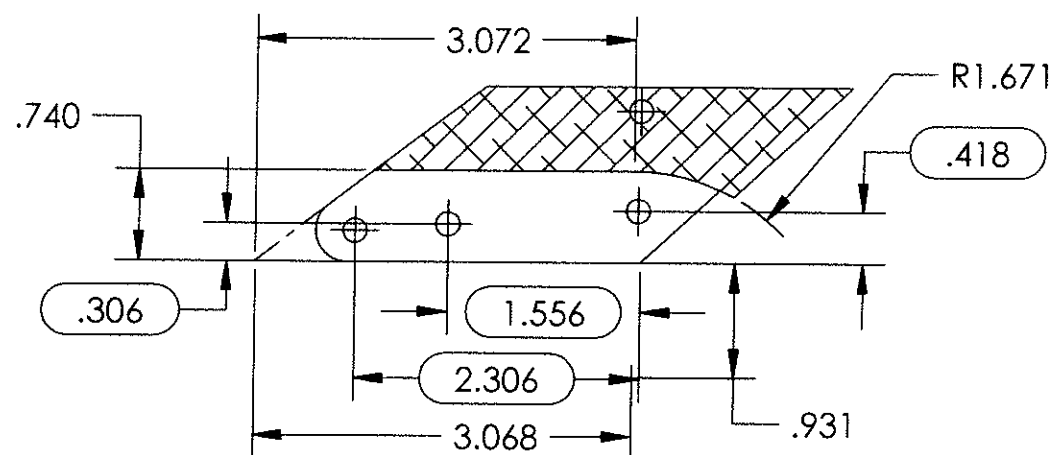
ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR	CHECKER D.BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 09-10-09		DEFLECTORS	
CONTRACT No.		647.3900	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	REV. C
		CAGE CODE 07MZ6	SCALE NONE
		DWG. NO. 647.3900	SHEET 5 OF 12

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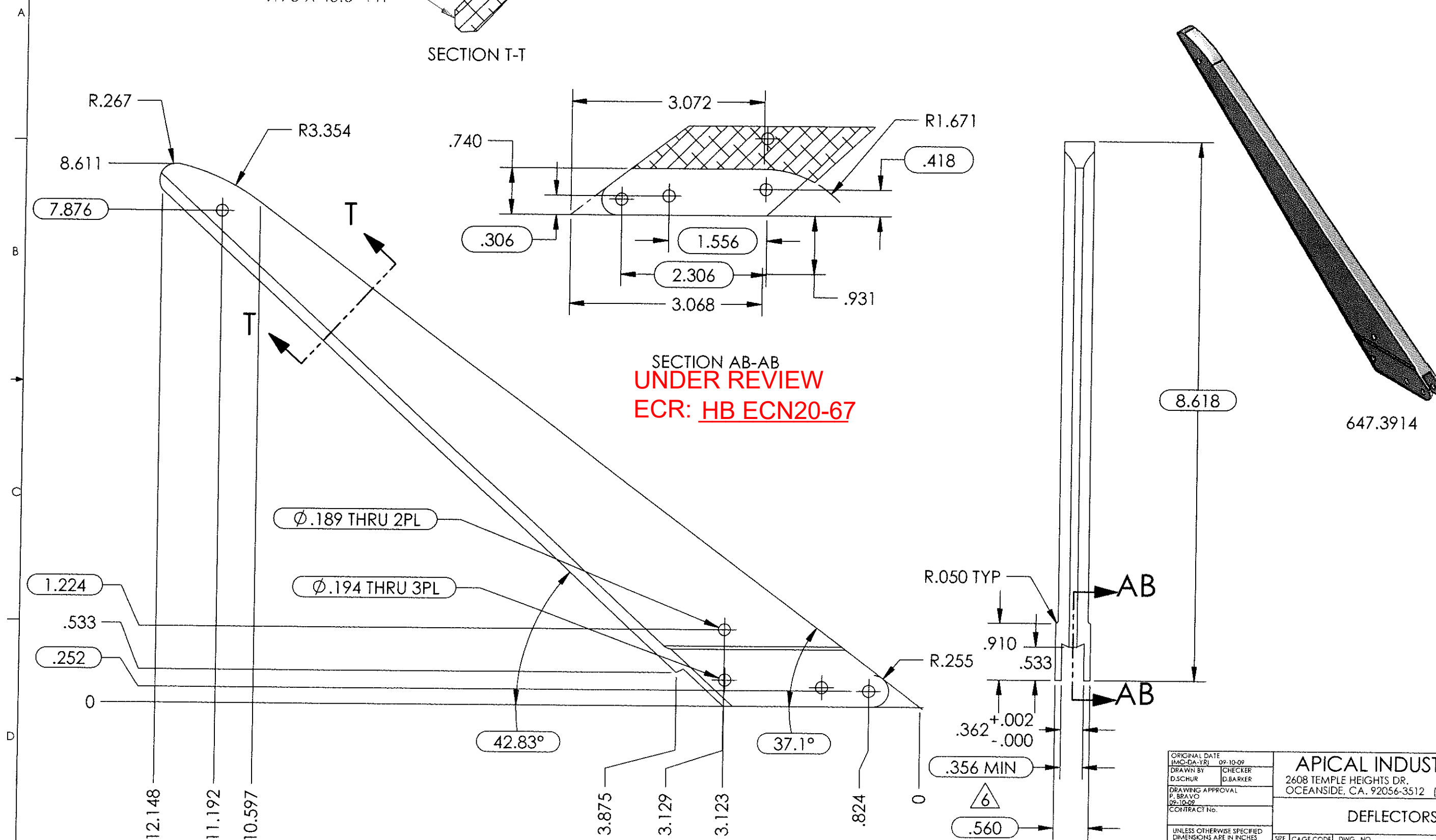
.175 X 45.0° TYP



SECTION T-T



SECTION AB-AB
UNDER REVIEW
ECR: HB ECN20-67



ORIGINAL DATE (MO-DA-YR) 09-10-09	<h1>APICAL INDUSTRIES</h1> <p>2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300</p>			
DRAWN BY D.SCHUR				
DRAWING APPROVAL P. BRAVO 09-10-09	<h2>DEFLECTORS</h2>			
CONTRACT No.				
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$	SIZE	CAGE CODE	DWG. NO.	REV.
	B	07MZ6	647.3900	C
	SCALE NONE			SHEET 6 OF 12

1 2 3 4 5 6 7 8

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A

B

C

D

2 PL $\triangle 5$ 11

10

12 6 PL

9

UNDER REVIEW
ECR: HB ECN20-67

$\triangle 5$

647.3903

ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.SCHUR	CHECKER D.BARKER		
DRAWING APPROVAL P. BRAVO 09-10-09		DEFLECTORS	
CONTRACT No.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		CAGE CODE 07M76	DWG. NO. 647.3900
		SCALE NONE	SHEET 7 OF 12

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42.760^{+0.010}
-0.000

6.480^{+0.010}
-0.000

9.000

UNDER REVIEW
ECR: HB ECN20-67

0
.171
.271
.646
1.000
2.699
4.389
5.054
6.480

1.732

33.205

37.040

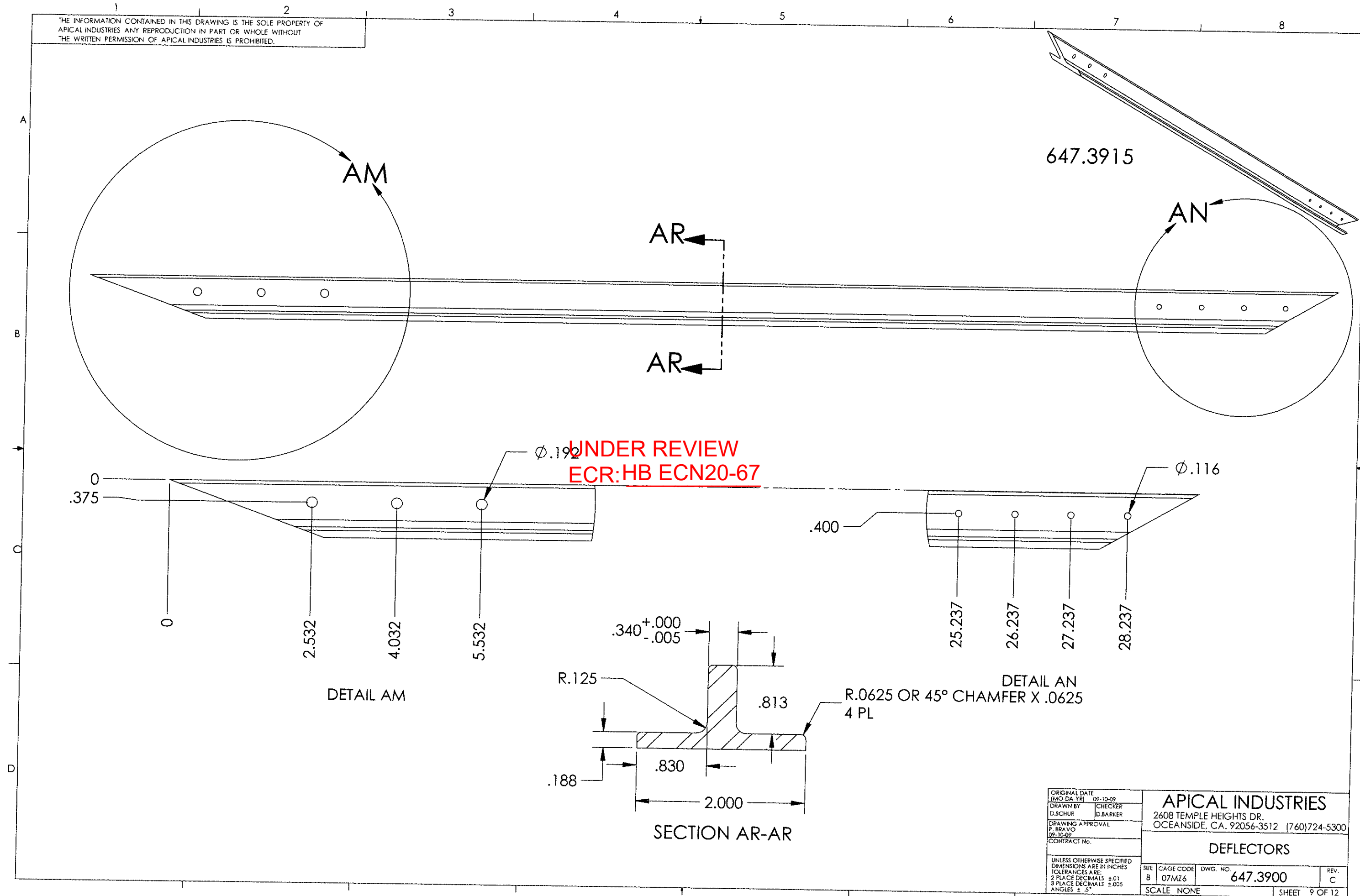
42.040

42.171

42.784

ORIGINAL DATE (MM-DD-YY) 09-10-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY D.SCHUP	CHECKER D.BARKER		
DRAWING APPROVAL P. BRAVO 09-10-09			
CONTRACT No.		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°			
SIZE B	CAGE CODE 07MZ6		
SCALE NONE		SHEET 8 OF 12	

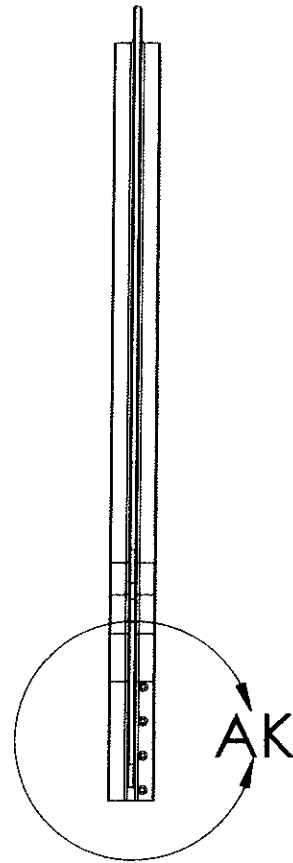
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ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR	CHECKER D.BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 09-10-09		DEFLECTORS	
CONTRACT No.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.3900
		SCALE NONE	SHEET 9 OF 12

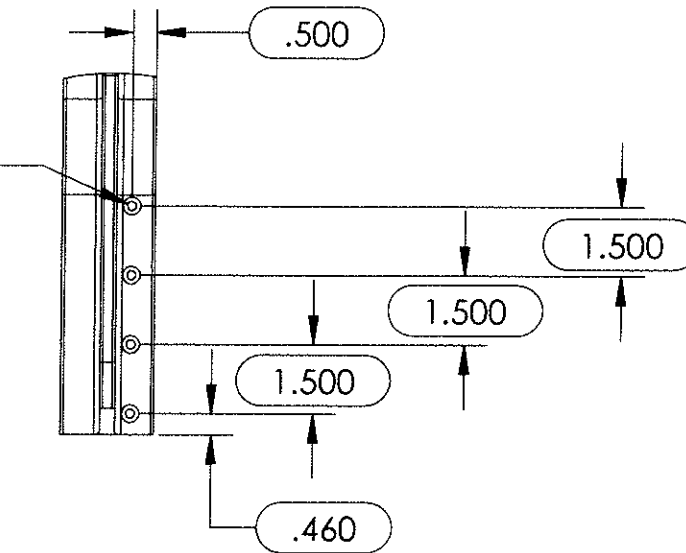
1 2 3 4 5 6 7 8

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4X $\phi .196 \pm .010$ THRU ALL
 $\checkmark \phi .385 \pm .020 \times 100^\circ \pm 1.000^\circ$

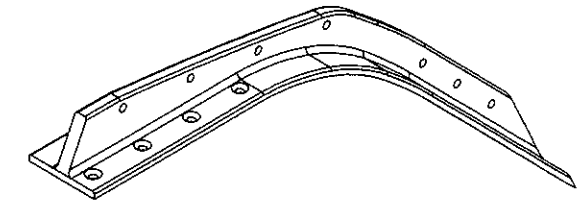
UNDER REVIEW
ECR: HB ECN20-67



647.3915

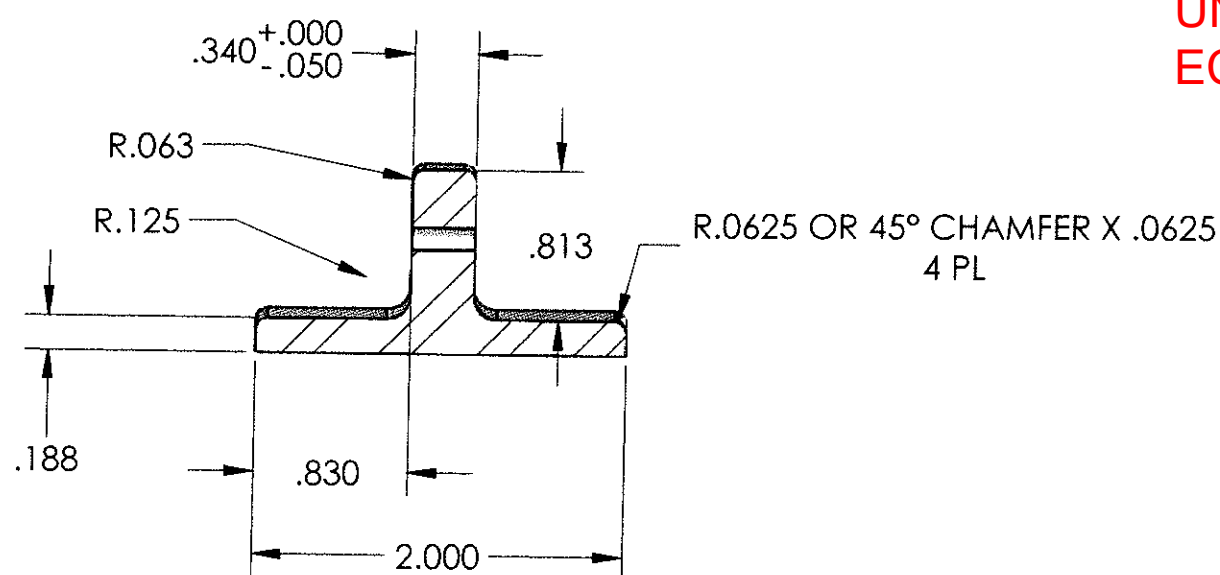
ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR		CHECKER D.BARKER	
DRAWING APPROVAL P. BRAVO 09-10-09		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT No.		DEFLECTORS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE B	CAGE CODE 07M26
		DWG. NO. 647.3900	REV. C
		SCALE NONE	SHEET 10 OF 12

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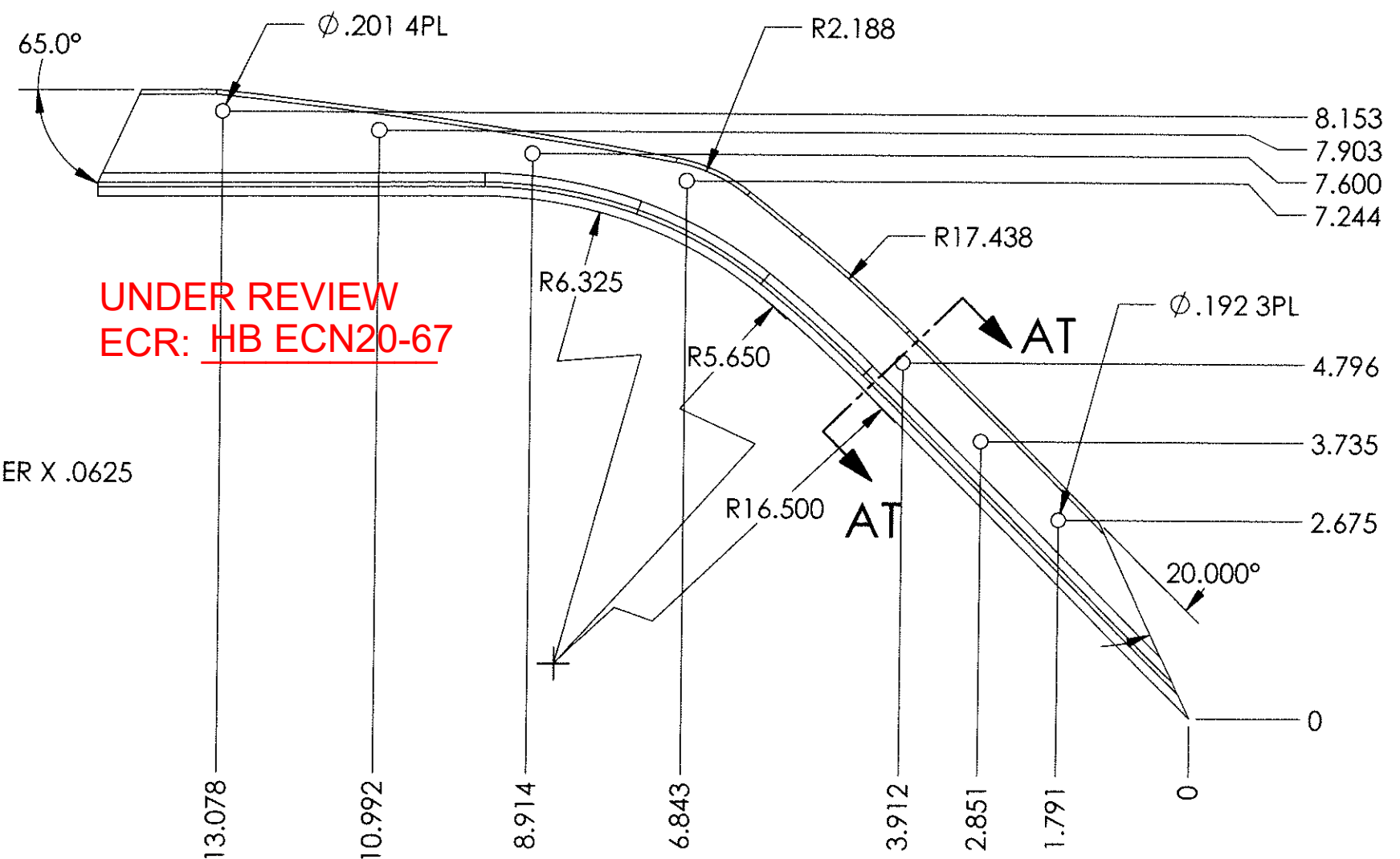


647.3916

UNDER REVIEW
ECR: HB ECN20-67



SECTION AT-AT



ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR	CHECKER D.BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO 09-10-09		DEFLECTORS	
CONTRACT No.		SIZE B	REV. C
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		CAGE CODE 07MZ6	DWG. NO. 647.3900
		SCALE NONE	SHEET 11 OF 12

1 2 3 4 5 6 7 8

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A

B

C

D

647.9317

UNDER REVIEW
ECR: HB ECN20-67

R.250
4 PL

.625

0 .500 2.000 3.500 6.500 8.000 9.500 10.000

.090

Ø.196
6 PL

ORIGINAL DATE (MO-DA-YR) 09-10-09		APICAL INDUSTRIES	
DRAWN BY D.SCHUR	CHECKER D.BARKER	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
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		SCALE NONE	SHEET 12 OF 12